

Work Order ID 131328

Thursday, April 02, 2015 11:53:31 AM

131328

Page 1

Item ID: D5124-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fwd Support

Start Date: 4/2/2015 Start Qty: 12.00

12

Cust Item ID:

Required Date: 4/2/2015 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 15-04-02

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5124	B

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FB340

Folio Rev: AB

Dwg Rev: B

Deburr

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

DAS

20

9-89

15-04-20

DAS

44

9-89

15/04/21

NCR →

DAS

20

9-89

15-04-20

DQA:

Date:

15/05/15

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

15/05/11

Work Order update only

Work Order: <u>131 328</u> Part No. <u>D5124-1</u> NCR No. <u>15-4932</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>			Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Date: <u>15-04-20</u>	Step #: <u>100</u>	QTY Effective: <u>2</u>	MRB (QSI042) Approval <u>A.P.</u>																																																																	
Description Work Order Deviation		Disposition		15.04.21																																																																
Measurement 2.796 +/- .010 is 2.782"... .004" under tolerance Operator ran the wrong program and didn't bolt down the part (1 Blank makes 2 Parts)		ACCEPTABLE @ 2.782, NO ACTION REQUIRED		Completed By DAS 20 15/04/20 9-89																																																																
				Lead hand / Supervisor Approval Verification DAS 14 15/04/21 9-89																																																																
				QC / QA Coordinator Approval DAS 9 15/04/21 9-89																																																																
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Work Order ID 131328

Thursday, April 02, 2015 11:53:31 AM

131328

Page 2

Item ID: D5124-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Support
 Start Date: 4/2/2015 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 4/2/2015 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

415-4-22

130

Identify as per dwg & Stock Location: st LGASS

0.00

130

Packaging

Memo

0.00

Packaging

DAS

27

APR 22 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ

15-04-23

mf

15-4-23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

Thursday, April 02, 2015 11:53:35 AM

Page 1

Work Order ID: 131328

131328

Parent Item: D5124-1

D5124-1

Parent Item Name: Fwd Support

Start Date: 4/2/2015

Required Date: 4/2/2015

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP rev A RQ verified by JLM 14/08/08

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D5124-1TRN

Manufactured No

Each 12.0000

12

D5124-1TRN

Support

6

DAS

20

9-89

15-04-19

Location

Loc Qty

Loc Code

MAT060

12

128835

6

130608

6

6

DQA: _____ Date: _____

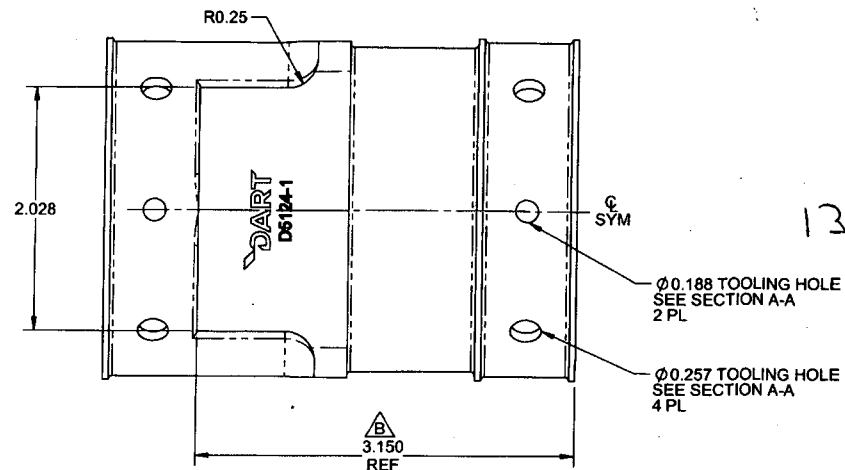


WORK ORDER NON-CONFORMANCE / UPDATE

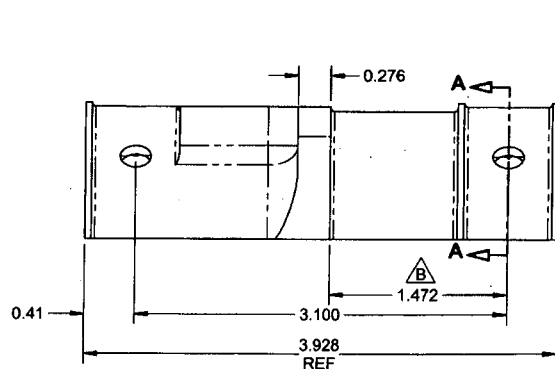
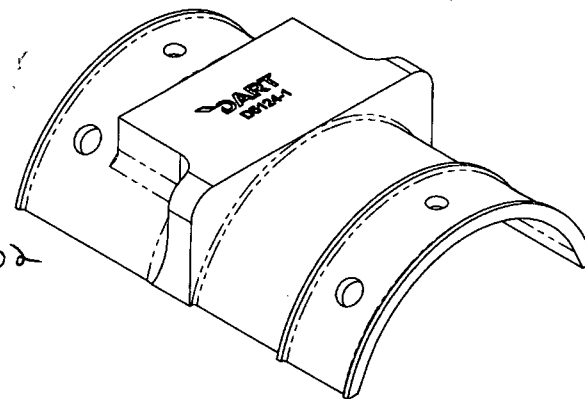
QA Closed: _____ Date: _____

Work Order update only ☐

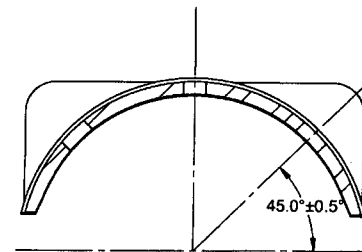
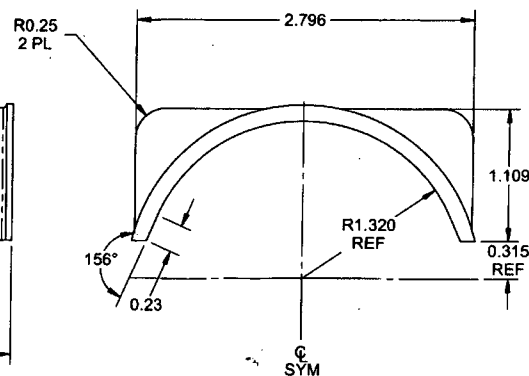
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Description Work Order Deviation				Disposition			Completed By																		
							Lead hand / Supervisor Approval Verification																		
							QC / QA Coordinator Approval																		
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131328
MLW
150402



D5124-1 FWD SUPPORT



SECTION A-A RELEASED

2014 NOV 18

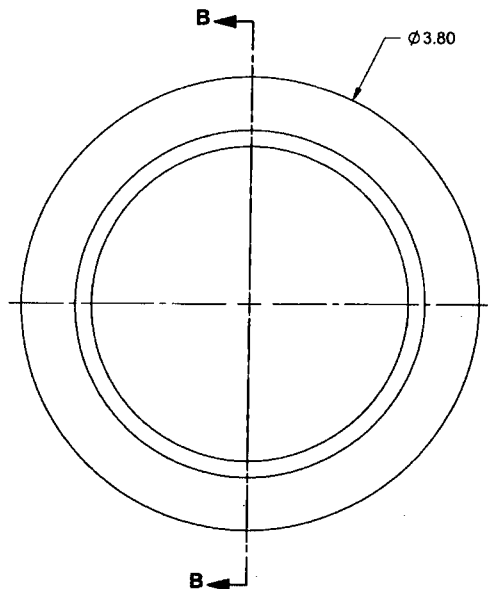
NOTES:

- 1) MATERIAL: MAKE FROM D5124-1TRN
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART LOGO AND P/N "D5124-1" IN AREA SHOWN
USING 0.125 HIGH X 0.010-0.020 DEEP LETTERING PER DART QSI 044 6.3,
IDENTIFY WITH DART B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.53 lbs
- 8) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D5124-1-REVB.SLDPRT"

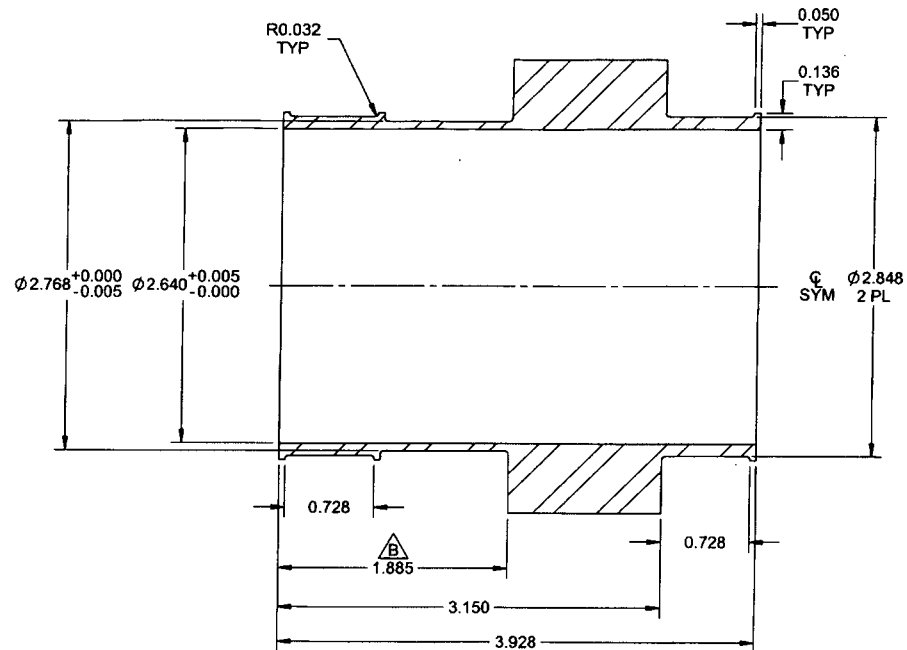
APPROVED

B	DIMENSIONAL CHANGES RESULTING FROM FIRST TEST FIT. SEE REV A FOR DETAILS	AP	14.10.28
A	NEW ISSUE	AP	14.08.07
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	CP	DRAWING NO. D5124	
MFG. APPR.	RQ	REV. B	
APPROVED	MP	TITLE	
DE APPR.	DS	FWD SUPPORT	
DATE	14.10.28	SHEET 1 OF 2	
		SCALE	
		NTS	

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D5124-1TRN FWD SUPPORT



SECTION B-B

RELEASED

2014 NOV 18

NOTES:

- 1) MATERIAL: 17-4PH/S17400/TYP 630 ROUND BAR PER AMS 5643 / ASTM A564, REF DART SPEC. M17-4-R H900 OR H925 CONDITION, MIN UTS = 170 KSI (38HRC)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.74 lbs

APPROVED

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	CP	DRAWING NO.	REV. B
MFG. APPR.	RQ	D5124	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	FWD SUPPORT	NTS
DATE	14.10.28	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	